

Date: Wednesday, 17/09/2008 10:48:26 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE  
 Job Number : 42055  
 Estimate Number : 13568  
 P.O. Number :  
 This Issue : 17/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D38143  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3814 PREL *proto*  
 Previous Run : Project Number : N/A  
 Material :  
 Due Date : 24/09/2008 Qty: 3 Um: Each  
 Written By : *JL 08.09.17*  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 08-09-03 JLM Verified By:EC

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X04000 6061-T6 Bar 1.00 x 4.00



Comment: Qty.: 0.4150 f(s)/Unit Total : 1.2449 f(s)  
 6061-T6 Bar 4.00" x 1.00"  
 BATCH: *M107221*

*JL 08/09/22*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blank 4.75" long

*JL 08/09/22*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA780 Rev. *AA* & Dwg D3814 Rev. *PREL*

2-Deburr per dwg D3814

3-Finish tapping hole to final depth as per Dwg D3814

*DTP 08/09/23*

(3)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DTP 08/09/23*

(3)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*JL 08/09/24*

(2)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42055

Part Number: D38143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten signature*

08-10-02

(23)

7.0

POWDER COATING

POWDER COATING



M 109152



(34)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*\*MASK THREADED HOLE PRIOR TO POWDER COAT\*\*\*

START TIME:

8:10

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:40

M-h 08/10/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03

(X3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten signature*

AS 08/10/03

(X3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08-09-12 AUTH U

RELEASED DATE

08/10/03

00252A

*Handwritten signature*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42055
<b>Description:</b> H/W-LF		<b>Part Number:</b> D3814-3
<b>Inspection Dwg:</b> D3814 <b>Rev:</b> PREL		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

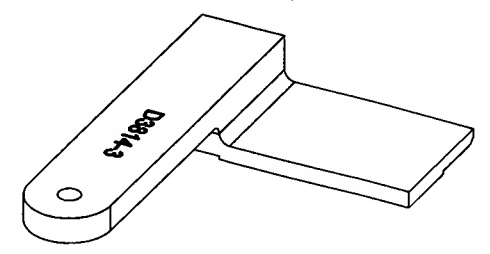
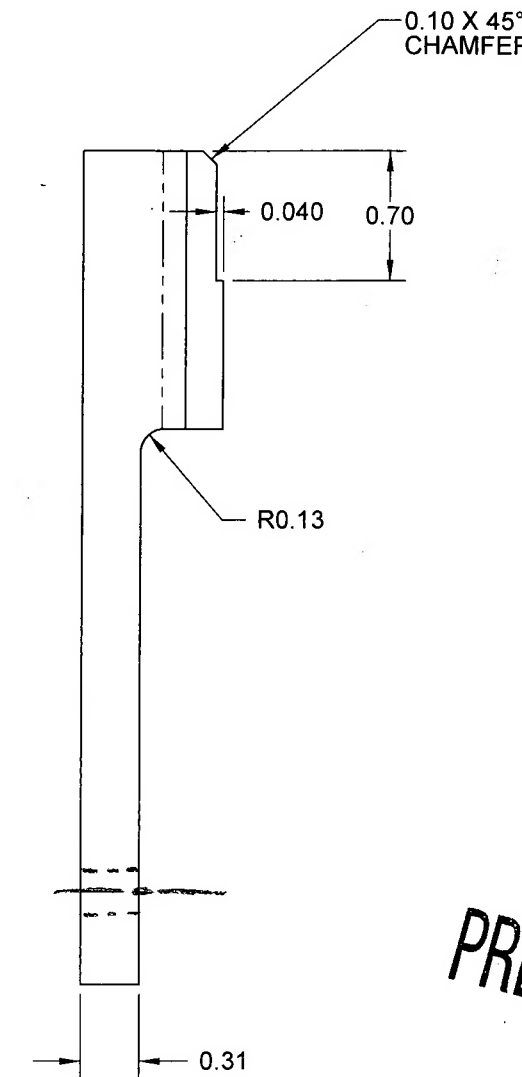
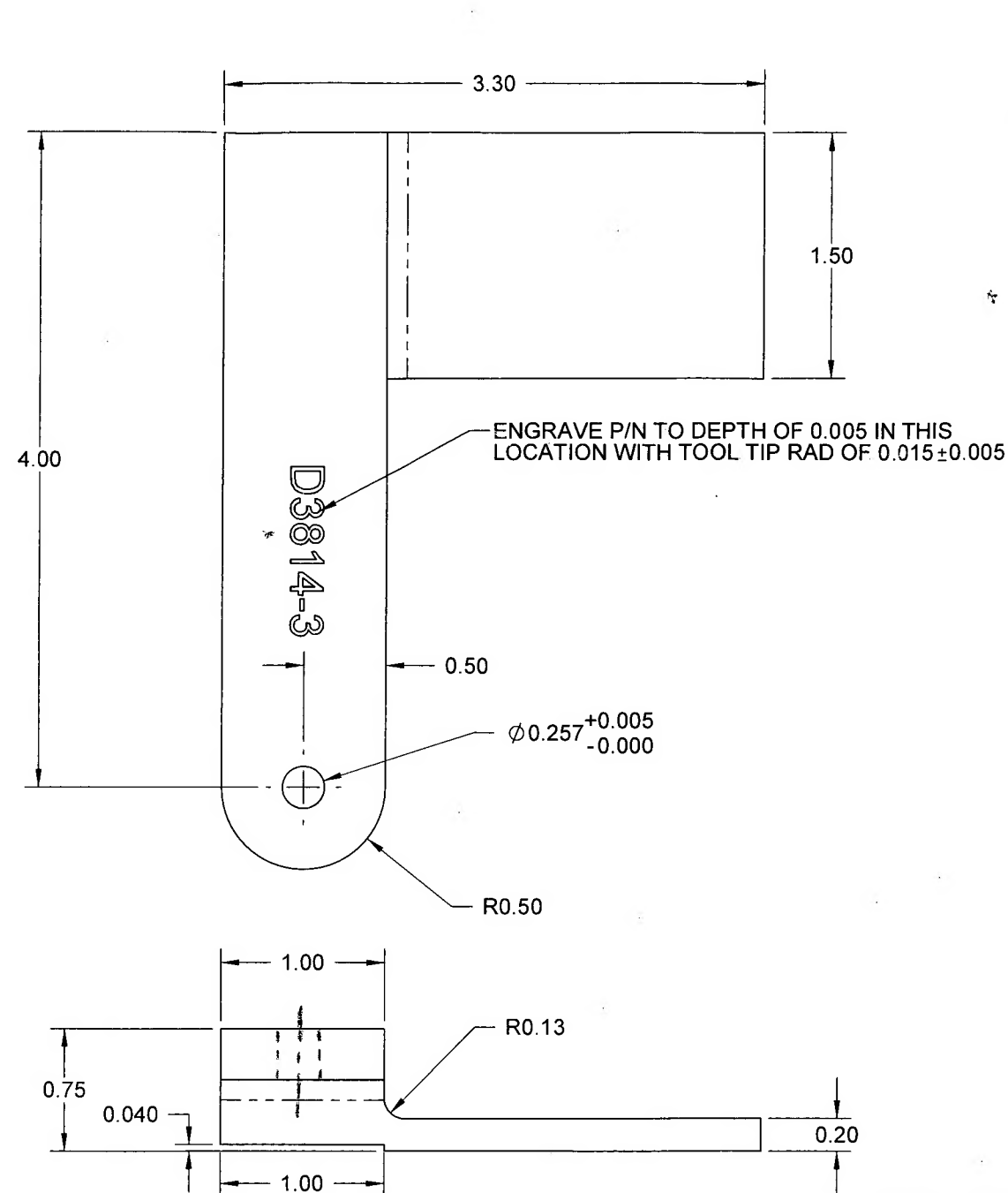
☒
**First Article**
☒
**Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.30	± 0.03	3.3	✓			
1.50	± 0.03	1.5	✓			
4.00	± 0.03	4.00	✓			
0.50	± 0.03	0.50	✓			
R0.50	± 0.03	0.50	✓			
Ø 0.257	+0.005/-0.004	0.260	✓			
1.00	± 0.03	1.00	✓			
0.75	± 0.03	0.749	✓			
0.040	± 0.010	0.040	✓			
1.00	± 0.03	1.003	✓			
R0.13	± 0.030	0.125	✓			
0.20	± 0.030	0.202	✓			
0.31	± 0.030	0.31	✓			
R0.13	± 0.03	0.125	✓			
0.70	± 0.03	0.700	✓			
0.040	± 0.03	0.040	✓			
45° x 0.10	± 0.03	0.100 x 45°	✓			

<b>Measured by:</b> DJP	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>
<b>Date:</b> 08/09/23	<b>Date:</b> 08/09/24	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

2777



**PRELIMINARY ISSUE**

**D3814-3 HINGE, LOWER AIRFRAME**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3814</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HINGE</b>	NTS
DATE	<b>08.09.11</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

